

DIRECTIONS
for CARE and
CLEANING

Continuous Strip
Lead and Rule
Molds

STYLE 1R MOLD, FOR RULES AND HIGH AND LOW LEADS AND SLUGS IN ANY GIVEN POINT-SIZE FROM 1½ TO 12-POINT INCLUSIVE.

STYLE 1RA MOLD, FOR HIGH OR LOW TIE-UP SLUGS AND ELECTROTYPE BEARERS IN 12-POINT (See ¶43).

STYLE 1RB MOLD, FOR 6-POINT COLUMN-RULE, ALSO 6-POINT STANDARD RULES AND HIGH AND LOW SLUGS (See ¶47).

TRADE MARK
MONOTYPE

Reg. U. S. Pat. Off.

LANSTON MONOTYPE
MACHINE COMPANY
PHILADELPHIA

Directions for Care and Cleaning

THE STYLE 1R

LEAD AND RULE MOLD

CAUTIONS

1. **Mold Blade stroke.** Products for which a **MATRIX** is used (rules and high leads or slugs with all **MOLDS**, also medium slugs with **Column Rule MOLDS**) must be cast with $\frac{1}{2}$ " stroke of the **MOLD BLADE**. Any more or any less than $\frac{1}{2}$ " will throw the **BLADE** out from register with the **MATRIX**, and in addition to giving an imperfect product, may injure the **MOLD**.

Product for which a **CAP** and **CAP SUPPORT** are used are cast with a $\frac{3}{4}$ " stroke of the **MOLD BLADE**. The stroke must never be made greater than this under any circumstances, but if necessary may be shortened, but never below $\frac{1}{2}$ ". When the stroke is shortened, the **CAP** and **CAP SUPPORT** must be moved to the right the amount the stroke is shortened, so that the **BLADE** and **CAP** will register.

2. **Mold not to be taken apart unless necessary.** It is not necessary to take the **MOLD** apart to change **MOLD BLADES**. If the **MOLD BLADE** show signs of hanging up, stop the machine, thoroughly oil all moving parts of the **MOLD** to be sure it is properly lubricated. This will usually free a **MOLD** if the **BLADE** or **VENT PUSHER** is hanging up. If the product being cast has become jammed proceed as follows:

Lock out the **PUMP**, remove the **SHIELD (G)**, **MATRIX CLAMP (T)** and **MATRIX (U)**, also the right **TIE BAR (V)** from the top of the **MOLD**. From the rule being cast cut some pieces about two picas long, turn the machine until the **MOLD BLADE** is at the left of its stroke, drop one piece of the rule into the **MOLD BLADE** opening and turn the machine over to push the rule out. Repeat until the **MOLD** is free from the rule which is binding. If the rule does not move when the machine is turned over it will be necessary to take the **MOLD** apart as described in the following pages; in which case thoroughly clean the **VENT PUSHER** slot with a piece of wood reget or brass rule.

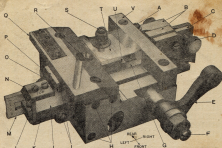


FIGURE 1.

Top view showing MOLD assembled with Rule MATRIX.

NOTE: Shield (G) is shown transparent to show CLAMP (T) and Matrix (U) in position.

3. Parts must correspond when changing Mold Blades. To change from one style of product to another be careful to have all parts of the same series. The parts in a series are carefully fitted to work together and cannot be interchanged with other sets of parts. They are clearly marked to prevent confusion.

4. Mold Screws. If the MOLD has the two diagonal holes in the BASE PLATE (one shown above letter H, Fig. 1) use the extra long MOLD SCREW a50E1, furnished with this MOLD, in the right-hand hole near the water holes and use two of the standard MOLD SCREWS a50E in the other two holes. For MOLDS not having these diagonal holes use the three standard MOLD SCREWS a50E and omit this extra long SCREW. Never use this extra long SCREW in any TYPE MOLDS as it would bottom in the MOLD and force the BLOCKS out of position.

5. Lubrication. Use "Rule Mold Oil" (order by name). In case of emergency mutton tallow or castor oil (lubricating or medicinal) may be used but we do not recommend their continued use. Standard MONOVYPE oil such as is used on other MOLDS and CASTING MACHINE parts will not work on this MOLD. Keep the OIL HOLE (R) in the left TIE BAR (Q) over the MOLD BLADE (M) constantly filled with one of these lubricants; also put a little on the end of the OPERATING BAR where it joins the MOLD BLADE (M) and on the end of the CLAMPING SCREW (F) where it

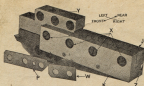


FIGURE 2.
TYPE BLOCKS AND POINT BLOCKS.

touches the TYPE BLOCK (K). This CLAMPING SCREW (F) must be removed completely and oiled its full length before the MOLD is put on the machine, and on long runs this must be done once a day.

6. When changing product, as for example, changing MATRICES to get a different face or changing from rules to leads, always save a piece about 4" long of the product just cast (see next paragraph). In the case of taking off a MATRIX wrap this piece with the MATRIX; in the case of low leads wrap it with the MOLD-BLADE CAP.

7. Before starting to cast insert between the TYPE BLOCKS a piece of the product for which the MOLD is then adjusted, and push this piece in far enough to touch the end of the MOLD BLADE. Loosen the KNURLED SCREW (D) on the FRICTION BLOCK (B) to clamp this product sufficiently to prevent the stroke of the PISTON blowing it out. NOTE: When a new MATRIX is received without a piece of the product proceed as follows: Insert between the TYPE BLOCKS, in the same manner as described above, a piece of lead or leads (either MONOTYPE or foundry) to equal the point-size to be cast. Before putting on the SHIELD (G) cover the MOLD BLADE opening between the MATRIX and the right TIN BAR (V) with ivory soap (or any similar soap that is soft enough so it does not crumble) and also force a little down into the opening. Put on the SHIELD (G). Throw the LATCH (operated by the PISTON-OPERATING-ROD CROSSHEAD) back out of commission and turn the machine over by hand for several casts until the new product is properly started. Then throw the LATCH in again.

8. First cast. Before starting to cast turn the machine over once by hand with the PUMP locked out, then release the PUMP and turn the machine over again by hand to make the first cast. This is to see that the MOLD and machine are working correctly before starting under power.

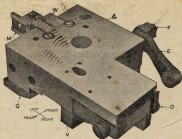


FIGURE 3.

Bottom view showing location of SCREW from BASE to TYPE BLOCKS.

9. **Temperature.** For product from six- to twelve-point, inclusive, the temperature should never exceed 725°; for product from two- to six-point it should never exceed 825°; for 1½-point the temperature should be about 850°. These temperatures are for standard Monotype metal. For other metals special care must be used to obtain the correct temperatures by trial; for example, linotype metal, frequently used in non-distribution newspaper offices, casts at lower temperature.

10. **Water regulation.** Use just sufficient water to give a perfect product. Too much will give imperfect faces and prevent perfect fusion of the joints; too little will cause blistered body. For 1½-point Molds more water is required than for other point sizes.

11. **Putting on a Mold.** Never attempt to put on a MOLD with the CASTING MACHINE at any other than the 15° position. Also be very particular to have the base of the MOLD and its seat on the machine perfectly clean and free from particles of metal.

12. **Alterations.** Never attempt to lap any part of the MOLD or alter its shape. These parts are made by experienced workmen trained for this special work and supplied with the finest gages and measuring instruments.

13. **Taking apart.** Never remove from the MOLD any other parts than those directed in the following under the heading "Taking Apart."

14. **Speed.** The speed for a given point-size is the same

for all products; that is, rules and high and low leads including the longer stroke for low leads. For 1½-point run about 110 r.p.m., for two-point run about 120 r.p.m., for three-point about 100 r.p.m., for four-point about 75 r.p.m., for six-point about 50 r.p.m., for ten-point about 30 r.p.m., for twelve-point about 25 r.p.m.

15. **Adjustment of Nozzle.** Always test the adjustments of the NOZZLE, especially the seating of the NOZZLE, before starting to cast.

16. **Action of Clamp Screw.** When the machine is running at 120 r.p.m. the moving end of LEVER (E) should be between horizontal and ⅜" below the horizontal, when the CENTERING-PIN LEVER is at the bottom of its stroke and the TYPE BLOCKS locked together in casting position. If the moving end of the LEVER (E) works down so that at the bottom of its stroke (machine running at 120 r.p.m.) it is more than ⅜" below the horizontal it must be readjusted. Be sure proper SPRING compression is on the CONNECTING ROD to this LEVER (E) when making this test. (See "Directions for Adjusting Lead and Rule Mold Attachment and Automatic Cutter.")

CAUTION: Twelve-point MOLDS operate better at the lower limit of ⅜"; that is, the CLAMPING LEVER should be set so that, when at the bottom of its stroke, its moving end is approximately ⅜" below the horizontal.

17. Each time a Mold is put on the machine or one Matrix is changed for another, test the product by laying two long lengths foot to foot on the GALLEY. If they do not touch throughout their length, adjust the GUIDE ROLLER to straighten them, and the CHANNEL PLATE SUPPORT to suit. (See "Directions for Adjusting Lead and Rule Mold Attachment and Automatic Cutter.")

TAKING APART: Re-read Cautions

(See the "direction arrow" on each figure)

18. Prepare a suitable place for taking the MOLD apart. Spread down a clean sheet of paper and as the parts are taken off the MOLD put them on it.

19. Before taking off any part back off CLAMP SCREW (F) two or three turns, using LEVER (E) to turn it.

20. Remove, in the order here given, SHIELD (G), MATRIX-CLAMP SCREW (S); MATRIX CLAMP (T); MATRIX (U); upper MOLD-BLADE SHOE (N); MOLD-BLADE STOP (L); MOLD BLADE (M) (CAUTION: Do not drop VENT PUSHER); and two TIE BARS (Q and V).

21. Take out one SCREW (& Fig. 3) and its WASHER from the bottom of the MOLD. Then from the front remove five SCREWS (I) that hold the front TYPE BLOCKS

(J and K) to the rear TYPE BLOCK (O): these are all at the left end, three near the top and two near the bottom—the lower right one and the upper right two are reached through holes (H). Slide the TYPE BLOCKS (J and K) out toward the left. Remove the two POINT BLOCKS (P and W, Fig. 2). (Note their position when taking them off so that they will be replaced correctly; their corners are made to correspond with those of the TYPE BLOCKS.)

22. Remove the six short SCREWS (X) (4 are shown in Fig. 2, the other 2 are underneath) and the one long SCREW (Y) from the TYPE BLOCKS and take the TYPE BLOCKS (J and K) apart.

CLEANING

23. Clean all parts thoroughly with a dry cloth free from lint. Never use waste.

24. Be particularly careful to have the VENT PUSHER slot (Z, Fig. 2) in the TYPE BLOCK clean.

ASSEMBLING

25. Put the TYPE BLOCKS (J and K) together; insert the six short SCREWS (X) and one long SCREW (Y) and bring them up to bearing. Get the left ends of the TYPE BLOCKS exactly even; try this with a straight edge or feel with the finger nail across the end and tap one or the other lightly with a block of wood, to bring the TYPE BLOCKS into position, then tighten the SCREWS and test again.

26. Slide the TYPE BLOCKS (J and K) into position, putting a slight downward pressure on them so as to remove any dirt from their bearings. Remove the TYPE BLOCKS, wipe them off and repeat, this time leaving them in position. NOTE: It is absolutely necessary to have the TYPE BLOCKS and their bearings in the MOLD perfectly clean; even the slightest particle of dirt would hold the TYPE BLOCKS out from position.

27. Move the TYPE BLOCKS (J and K) forward a little, slide in the MOLD BLADE, and press the TYPE BLOCKS back against the MOLD BLADE. Insert the upper POINT BLOCK (P) with the beveled corner coinciding with the beveled corners of the TYPE BLOCKS, press it down lightly with the thumb nail to take up all lost motion in the MOLD BLADE, and insert and bring just up to bearing its three SCREWS, but do not tighten these SCREWS. Turn the MOLD bottom up and insert and bring just up to bearing the SCREW (A). Insert the lower POINT BLOCK (W) with its beveled corner coinciding with the beveled corners of the TYPE BLOCKS, push it in until it is flush or below the surface of the TYPE BLOCKS and then insert and bring

just up to bearing its two SCREWS. Turn the MOLD right side up again and test the position of the upper POINT BLOCK by seeing that there is no up-and-down play in the MOLD BLADE. Then go over the three SCREWS (H), the two SCREWS (I), and the SCREW (K), tightening each a little until all are brought up solid. Again test the MOLD BLADE to see that there is no up-and-down play in it.

28. Pull out the MOLD BLADE (M). With the MOLD standing on its front side, with the left end toward you, put in the VENT PUSHER with the sharp edge up and the lug on the end toward you.

29. Slide in the MOLD BLADE again gently until the square slot in the BLADE engages the lug on the end of the PUSHER and push both gently in together, swinging the BLADE over so little, if necessary, to enter its end in its slot. If the BLADE and PUSHER do not go in readily, remove them and start over. Never force the BLADE.

30. Put on the upper MOLD-BLADE SHOE (N) with its two SCREWS, and also the MOLD-BLADE STOP (L).

31. Put on the two TIE BARS (Q and V) and bring them toward each other so that the SHIELD (G) will just slide easily into place between them.

32. Put on the desired MATRIX (U); MATRIX CLAMP (T); MATRIX-CLAMP SCREW (S); SHIELD (G).

33. FRICTION BLOCK: This does not need to be taken off when cleaning the MOLD, but if required it can be taken apart and reassembled as follows: Remove the two SCREWS holding the TRIMMER, shown just to the left of SCREW (D) in Fig. 1, and take off the TRIMMER and its PACKING PLATE. Hold the CLAMP (C) to the rear and remove the SCREW (D) with its WASHER; then remove the CLAMP (C) and its SPRING. Remove the two SCREWS (A) and take off the FRICTION BLOCK (B). To replace the FRICTION BLOCK proceed as follows: Insert a piece of lead or rule (cast by this MOLD) into the opening from which it was ejected and push it in until it touches the end of the MOLD BLADE, which can be told by seeing that moving the MOLD BLADE moves the lead or rule. Turn the LEVER (E) over until the lead or rule just inserted is clamped tightly. Press the FRICTION BLOCK (B) against its two bearing surfaces and slide it forward until it touches the lead or rule which is projecting from the MOLD; then insert and set up very tight its two SCREWS (A). Remove the piece of lead or rule from the MOLD, insert the SPRING behind the CLAMP (C), put this CLAMP (C) in position and hold it to the rear while inserting and tightening the RELEASE SCREW (D). Be sure the WASHER is on the SCREW (D). Put in position the TRIMMER with its Pack-

ING PLATE and insert and tighten its two SCREWS shown just to the left of the SCREW (D) in Fig. 1. Be sure the PACKING PLATE is inserted right side up so that its upper edge comes about flush with the top of the FRICTION BLOCK. Back off the RELEASE SCREW (D) until it is just free. On some of the earlier MOLDS there was a SHOE under the CLAMP (C), but the method of taking apart and putting together is the same as in the preceding. Some of the earlier MOLDS had an ADJUSTING SCREW in the rear of the FRICTION BLOCK instead of the RELEASE SCREW (D). This ADJUSTING SCREW is adjusted by screwing it in until the shoulder on it comes flush with the rear face of the FRICTION BLOCK (B).

34. Screw in to bearing the CLAMP SCREW (F), turning it by the LEVER (E). For directions for adjusting this CLAMP SCREW see ¶16. Be sure a piece of the product is left in the MOLD.

Directions for Changing Product

RULES TO HIGH LEADS

35. High leads are cast from a special MATRIX of about .004" depth of drive. Changing from rules to high leads is, therefore, only a matter of changing MATRICES the same as when changing from one face of rule to another. Remove the SHIELD (G) and the MATRIX CLAMP (T), exchange MATRICES (U) making sure the new MATRIX is put on with the open end of face to the right and replace the MATRIX CLAMP (T) and SHIELD (G). Changing back to rule casting is similar to above.

RULES OR HIGH LEADS TO LOW LEADS

36. To change from casting rules or high leads to casting low leads requires a change of MOLD BLADES as follows:

37. Take off the SHIELD (G), MATRIX CLAMP (T), and MATRIX (U). Take off the MOLD-BLADE STOP (L). Pull out the MOLD BLADE (M) taking care not to drop the VENT PUSHER which is drawn out with it.

38. Clean thoroughly the end of slot (Z, Fig. 2) for the MOLD BLADE and VENT PUSHER.

39. Turn the MOLD on its front side and put in the VENT PUSHER and MOLD BLADE in the same way as described under "Assembling" (¶28 and ¶29).

40. Put on the MOLD-BLADE STOP (L) (marked "L" for low BLADE) and tighten its SCREWS.

41. Put on the MOLD-BLADE CAP with its Support. The MOLD-BLADE CAP goes in the MOLD BLADE opening

with its open side up and its notched end to the left: push the lug on its left end in under the POINT BLOCK until the vertical face of the notch comes up solid against the side of the POINT BLOCK. Put on the MATRIX CLAMP (T) and SHIELD (G).

LOW LEADS TO RULES OR HIGH LEADS

42. To change from low leads to rules or high leads proceed in a similar manner to that described in the preceding under heading "Rules or High Leads to Low Leads." Substitute the high BLADE (M) and its STOP (L) (marked "H") for the low BLADE (M) and its STOP (L) (marked "L"), and a MATRIX (U) for the MOLD-BLADE CAP and its SUPPORT. Be sure to have the open end of the MATRIX to the right.

LOW LEADS OF ONE HEIGHT TO ANOTHER

43. If the MOLD be equipped with more than one MOLD-BLADE CAP for casting low leads of different heights with the same low BLADE the change is made as follows:

44. If the MOLD is on the Machine have the CENTERING-PIN LEVER at the top of its stroke, or if off the machine have the CLAMPING SCREW (F) backed off so the TYPE BLOCKS (J and K) do not bind the CAP. Remove the SHIELD (G), MATRIX CLAMP (T) and MOLD-BLADE CAP with its SUPPORT; put on the required MOLD-BLADE CAP and its SUPPORT as described in ¶41. When removing or replacing the CAP do not try to force it or it will be bent or broken—it should slip in or out easily.

Directions for Care and Cleaning Style 1RA Tie-Up Slug Mold

For casting twelve-point tie-up slugs, either high or low, and also twelve-point electrotype guards in continuous strips of any length.

45. The construction of this Style 1RA MOLD is similar to the standard Style 1R LEAD AND RULE MOLD except that the MOLD BLADE is recessed so that a corresponding recess is cast in the side of the lug. The directions for care and cleaning the Style 1R LEAD AND RULE MOLD given in the preceding pages therefore apply equally to this Style 1RA TIE-UP SLOG MOLD.

46. CAUTION: Standard Rule MATRICES for use with the Style 1R RULE MOLD cannot be used on this Style 1RA

TIE-UP SLUG MOLD. The only MATRIX which can be used with this MOLD is the twelve-point MATRIX for casting a six-point face on the edge of the body (MATRIX 961RL).

Directions for Care and Cleaning Style 1RB Column Rule Mold

For casting six-point column rule, also rules from any standard six-point Rule MATRIX as well as three heights of six-point slugs.

47. The construction of this Style 1RB MOLD is similar to the standard Style 1R LEAD AND RULE MOLD and the same directions given in the preceding pages for the Style 1R MOLD therefore apply to the Style 1RB MOLD with the following additions:

48. The Column Rule MATRIX (.063" depth of drive) goes on the TYPE BLOCKS direct; all other MATRICES (that is, our standard Rule MATRICES, .030" depth of drive) require the PACKING PIECE between the TYPE BLOCKS and the MATRIX (see "Caution" below).

49. The MATRIX CLAMP marked "Rule and Body Height .888"" is to be used for clamping the MATRIX for any rule and also for the CAP SUPPORT for leads .888" in height. All other height leads require the CLAMP marked "All Leads except .888".

50. CAUTION: When putting on a standard Rule MATRIX and the PACKING PIECE beneath it be sure both are perfectly clean and back solid against the rear and left stops (with the lug on the PACKING PIECE to the right) when tightening the MATRIX CLAMP. If they are not against their stops the PACKING PIECE will be injured and the product will be cast with an overhang on one side. When the MOLD is equipped with two CAPS and CAP SUPPORTS, for casting two heights of low slug, be sure the CAP and CAP SUPPORT used together are both marked with the height of the low slug to be cast.

51. CAUTION: Care should be taken in removing the PACKING PIECE from the MOLD to prevent bending it. Remove that portion of the product just cast that has remained in the MOLD and then carefully lift out the PACKING PIECE with the fingers. Do not use a screw driver nor any other kind of tool to pry off the PACKING PIECE.

In case of a squirt it will be necessary, before trying to remove the PACKING PIECE, to first take off the right TIE BAR and the FRICTION BLOCK (complete). Then slide out the PACKING PIECE and metal together.

Names and Symbols of Parts of the Continuous Strip Molds

NOTE 1: This list is for all Style 1R Lead and Rule Molds, Style 1RA Tie-Up Slug Molds, and Style 1RB Column Rule Molds except as follows: Style 1R Lead and Rule Molds Nos. 1 to 17 inclusive in the two-point size are radically different from later Molds and when a part which can be applied outside our factory is required for one of these Molds the old part must be sent to us with the order for identification.

NOTE 2: All parts which can be furnished for applying to a Mold outside our factory are designated by an asterisk (*) preceding the symbol (See also special note following Mould-name: Car at 11MC1R1).

When referring to the following group see Note R1 for Style 1R Lead and Rule Molds as follows: 2-point Nos. 18 to 230, inclusive; 3-point Nos. 1 and 2; 4-point No. 1; 6-point prior to No. 95; 10-point No. 1; and 12-point Nos. 1 to 6, inclusive; and for all Style 1RA Tie-Up Slug Molds prior to No. 21.

BASE PLATE.....	b1MA1R1
bushing (2).....	a1MA1R2
plug screw (4).....	2235 * 1MA1R5

When referring to the following group see Note R5 for all Style 1RB Molds.

NUMBER PLATE.....	* 3MA1R1
screw (2).....	251 * 3MA1R2

When referring to the following group see Note R1 for Style 1R Lead and Rule Molds as follows: 2-point Nos. 18 to 230, inclusive; 3-point Nos. 1 and 2; 4-point No. 1; 6-point prior to No. 95; 10-point No. 1; and 12-point Nos. 1 to 6, inclusive; and for all Style 1RA Tie-Up Slug Molds prior to No. 21.

CLAMP SCREW.....	* 7MA1R1
bushing.....	7MA1R2
lever.....	* a7MA1R3
" lock nut.....	324 * 7MA1R5

When referring to the following group see Note R2 for Style 1R Lead and Rule Molds as follows: 2-point Nos. 18 to 123, inclusive; 6-point prior to No. 127; and 12-point No. 1.

FRUCTION BLOCK.....	a9MA1R1
clamp.....	a9MA1R2
" release screw.....	* a9MA1R4
" " washer.....	435 * a9MA1R5
" spring.....	6179 * 9MA1R6
plug screw.....	a9MA1R3
screw (2).....	2168 * 9MA1R7
" washer (2).....	438 * 9MA1R8
trimmer.....	* a9MA1R9
" packing plate (give point-size)....	* a9MA1R10
" screw (2).....	232 * a9MA1R11

*Can be applied without retreating the Mold to our factory.

When referring to the following group see Note R3 for Style 1R Lead and Rule Molds as follows: 2-point Nos. 18 to 14-4, inclusive; 8-point prior to No. 146; and 12-point No. 1.

TIE BAR (left)..... a10MA1R1
screw (2).....2224..* a10MA1R2

When referring to the following group see Note R3 for 1½-point Style 1R Lead and Rule Molds.

TIE BAR (right)..... 11MA1R1
screw (2).....2213..* 11MA1R2

When referring to the following group see Note R4 for all Style 1RA Tie-Up Slug Molds and Note R5 for all Style 1RB Column Rule Molds.

MOLD BLADE (high, give point-size and height) a1MC1R1

MOLD BLADE (low, give point-size and height) a2MC1R1

When referring to the following group see Note R5 for all Style 1RB Column Rule Molds.

†MOLD-BLADE CAP (give height of lead and point-size).....†a11MC1R1
support..... a11MC1R2

†NOTE: If the MOLD-BLADE CAP a11MC1R1, used in casting low leads, be broken, this part can be replaced by returning to us the broken pieces of the CAP together with MOLD-BLADE-CAP SUPPORT a11MC1R2, provided these broken pieces are in such condition that the required measurements can be obtained from them.

MOLD-BLADE POINT BLOCK (lower)..... 5MC1R1
(upper)..... a5MC1R2
bushing (in a5MC1R2)..... a5MC1R3

MOLD-BLADE STOP..... 7MC1R1
screw (2).....2236..* 7MC1R2

MOLD-BLADE SHOE (2)..... 9MC1R1
screw (4).....2243..* 9MC1R2

When referring to the following group see Note R8 for all 1½-point Style 1R Molds; Note R4 for all Style 1RA Tie-Up Slug Molds, and Note R5 for all Style 1RB Column Rule Molds.

TYPE BLOCK (rear, large)..... a1MD1R1
bushing..... a1MD1R16
plug screw (5).....2239..* 1MD1R7
screw (to b1MA1R1, bottom).....2161..* 1MD1R11
" (from b1MA1R1, side) (2).....2168..* 1MD1R12
" (through 5MC1R1 and 2) (5).....2223..* 1MD1R15
screw/washer.....435..* 1MD1R14

When referring to the following group see Note R5 for all Style 1RB Column Rule Molds.

TYPE BLOCK (front, upper)..... a2MD1R1
(front, lower)..... a2MD1R13
plug screw (in a2MD1R1) (3).....2239..* 2MD1R5
" (in a2MD1R13) (3).....2239..* 2MD1R14
screw (to b1MA1R1).....2161..* 2MD1R7

*Can be applied without returning the Mold to our factory.

Type Block (continued)

bushing (in a2MD1R1) (2).....	a2MD1R18
(in a2MD1R19) (2).....	a2MD1R19
screw (bottom) (2).....	2166 * 2MD1R8
(side) (4).....	243 * 2MD1R9
(top).....	242 * 2MD1R15
washer.....	435 * 2MD1R16
vent pusher.....	a2MD1R17

When referring to the following group see Note R3 for all 1½-point Style 1R Molds; Note R4 for all Style 1RA Tie-Up Slag Molds and Note R5 for 1RB Molds.

TYPE-BLOCK MATRIX ABUTMENT.....	10MD1R1
screw.....	233 * 10MD1R2

When referring to the following group see Note R5 for all 1½-point Style 1R Molds; Note R6 for Style 1R Lead and Rule Molds as follows: 2-point Nos. 18 to 168, inclusive; 6-point, prior to No. 146; and 12-point Nos. 1, 2, and 3; and see Note R5 for all Style 1RB Column Rule Molds.

TYPE-BLOCK MATRIX CLAMP.....	* 11MD1R1
screw.....	2225 * a11MD1R2
sleeve.....	* a11MD1R3
spring.....	6182 * a11MD1R4
abutment (lower).....	* a11MD1R5
" " (upper).....	438 * a11MD1R6

When referring to the following group see Note R4 for all Style 1RA Tie-Up Slag Molds.

TYPE-BLOCK PACKING BLOCK (give point-size).....	12MD1R1
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When referring to the following group see Note R7 for all Style 1R Lead and Rule Molds as follows: 2-point Nos. 18 to 168, inclusive; 6-point prior to No. 146; 12-point Nos. 1, 2, and 3.

TYPE-BLOCK SHIELD.....	* a13MD1R1
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For all 1½-point Style 1R Molds
see Note R8 for.....
a14MD1R1
a14MD1R2

Supplementary List

Giving Parts on Molds Which Differ from the Standard Parts as Given in the Foregoing Main List.

Note R1: Style 1R Lead and Rule Molds, 2-point Nos. 18 to 250, inclusive, 3-point Nos. 1 and 2, 4-point No. 1, 6-point prior to No. 95, 10-point No. 1, and 12-point Nos. 1 to 6, inclusive, and Style 1RA Tie-Up Slag Molds prior to No. 21 were equipped with the following parts:

BASE PLATE.....	1MA1R1
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*Can be applied without returning the Mold to our factory.

CLAMP SCREW lever (state whether straight or curved) . . . *	7MA1R3
" ball stud *	7MA1R4
CLAMP-SCREW-LEVER-BALL-STUD SOCKET . . . *	8MA1R1
plug *	8MA1R2
" lock nut *	8MA1R3

Note R2: Style 1R Lead and Rule Molds, 2-point Nos. 18 to 125, inclusive, 6-point prior to No. 127, and 12-point No. 1 were equipped with the following parts:

FRICTION BLOCK	9MA1R1
clamp	9MA1R2
" adjusting screw *	9MA1R3
" " " adjusting nut . . . *	9MA1R12
" " " lock nut . . . 310 . *	9MA1R13
trimmer *	9MA1R9
" screw (2) 2166 . *	9MA1R11

and omitted 9MA1R4, 9MA1R5, and 9MA1R10.

Note R3: Style 1R Lead and Rule Molds, 2-point Nos. 13 to 144, inclusive, 6-point prior to No. 146, and 12-point No. 1 were equipped with the following parts:

TIE BAR (left)	10MA1R1
screw (2) 2161 . *	10MA1R2

Note R4: All Style 1RA Tie-Up Slug Molds are equipped with the following parts:

MOLD BLADE (give point-size and height) . . .	1MC1RA1
TYPE BLOCK (rear, large)	61MD1RA1
bushing (2)	a1MD1RA16
TYPE-BLOCK MATRIX ABUTMENT	a10MD1RA1
TYPE-BLOCK PACKING BLOCK	12MD1RA1

NOTE: The above parts of the Style 1RA Tie-Up Slug Mold replace the corresponding parts of the Style 1R Lead and Rule Mold. All other parts of the Style 1RA Tie-Up Slug Mold are the same as their corresponding parts of the Style 1R Lead and Rule Mold.

Note R5: All Style 1RB Column Rule Molds are equipped with the following parts:

NUMBER PLATE *	3MA1RB1
MOLD BLADE (high, give point-size and height)	1MC1RB1
* MOLD BLADE (low, give point-size and height)	2MC1RB1
MOLD-BLADE CAP (give height of lead and point-size) †	11MC1RB1

† NOTE: If the MOLD-BLADE CAP a11MC1RB1, used in casting low leads, be broken, this part can be replaced by returning to us the broken pieces of the Cap together with MOLD-BLADE-CAP SUPPORT a11MC1RB2, provided those broken pieces are in such condition that the required measurements can be obtained from them.

*Can be applied without returning the Mold to our factory.

TYPE BLOCK (rear, large)	a1MD1RB1
TYPE BLOCK (front, upper).....	a2MD1RB1
(front, lower).....	a2MD1RB13
TYPE-BLOCK MATRIX CLAMP.....*	11MD1RB1
packing piece.....†	11MD1RB7
" " (low shoulder).....‡	11MD1RB8

†NOTE: This can be replaced without returning the Mold to our factory, provided the old PACKING PIECE be returned to us in such condition that the necessary measurements can be obtained from it.

[NOTE:] For casting low shoulder 3 points wide with rule of 2-point face or less, close to side of body on 6- to 12-point RH Molds. Furnished on special order only. Can be applied without returning the Mold to our factory.

NOTE: The above parts of the Style 1EB Column Rule Mon replace the corresponding parts of the Style 1R Lead and Rule Mon. All other parts of the Style 1EB Column Rule Mon are the same as their corresponding parts of the Style 1R Lead and Rule Mon.

Style 1RB Molds No. 71 and following are equipped with the following part, which is interchangeable with the superseded part 10MD1R1 on previous 1RB Molds.

Type-block Matrix Argument 10MDJRB1

Note R6: Style 1R Lead and Rule Molds, 2-point Nos. 18 to 168, inclusive, 4-point prior to No. 146, and 12-point Nos. 1, 2 and 3 were assigned with the following parts:

TYPE-BLOCK MATRIX CLAMP SCREW . . . 2223 . . * 11MD1R2
washer . . . 420 . . * 11MD1R6

and omitted all MT1B, all MT1B4 and all MT1B5.

Note R7: Style 1R Lead and Rule Molds, 2-point Nos. 18 to 148, inclusive, 6-point prior to No. 146. 12-point Nos. 1, 2 and 3, were assigned with the following parts:

TYPE-BLOCK SHIELD..... 13MD1R1

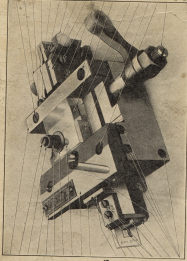
Note R8: All 1 1/4-point Style 18 Lead and Rule Molds are equipped with the following parts:

TIE BAR (right).....	a11MA1R3
TYPE BLOCK (rear).....	a1MD1R17
TYPE BLOCK (front, upper).....	a2MD1R90
TYPE BLOCK (front, lower).....	a2MD1R21
TYPE-BLOCK MATRIX ABUTMENT.....	a10MD1R4
TYPE-BLOCK MATRIX CLAMP.....*	a11MD1R9
TYPE-BLOCK FACING.....	a14MD1R1
TYPE-BLOCK FACING BUSHING.....	a14MD1R2

and omit 11MD1R1, a1MD1R1, a2MD1R1, g2MD1R13, 10MD1R1 and 11MD1R1. All other parts are the same as for other point size molds.

*Can be applied without returning the Mold to our factory

The Bar 11MA1R1
 Screw a11MD1R2
 Adjuster a11MD1R6
 Screw 9MA1R2
 Plate 3MA1R1
 Spring a11MD1R4
 Adjuster a11MD1R5
 Sleeve a11MD1R3
 The Bar a10MA1R1
 Type Block a1MD1R1
 Screw (5) 1MD1R7
 Bushing a1MD1R16
 Type Block a2MD1R1
 Shoe (2) 9MC1R1
 Mold Blade a1MC1R1
 Mold Blade a2MC1R1
 Screw (4) 9MC1R2
 Scoop 7MC1R1
 Screw (2) 7MC1R2
 Screw (5) 1MD1R15



11MA1R2 Screw (2)
 a9MA1R1 Block
 9MA1R7 Screw (2)
 9MA1R8 Washer (2)
 a9MA1R2 Clamp
 a9MA1R5 Washer
 a9MA1R4 Screw
 a9MA1R10 Plate
 a9MA1R9 Trimmer
 a9MA1R11 Screw (2)
 11MA1R2 Screw (2)
 10MD1R1 Adjuster
 10MD1R3 Screw
 a18MD1R1 Shield
 11MD1R1 Clamp
 7MA1R2 Bushing
 a10MA1R2 Screw (2)
 7MA1R1 Screw
 a11MC1R1 Cap
 a11MC1R2 Support

Screw 2MD1R15

Screw (2) 2MD1R3

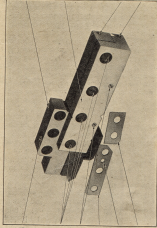
Screw (4) 2MD1R9

Screw (3) 2MD1R14

Point Block 25MC1R2

Bushing 25MC1R3

Block 25MC1R1



25MD1R1 Type Block

25MD1R18 Bushing

25MD1R13 Type Block

25MD1R19 Bushing

12MD1R1 Block

2MD1R5 Screw (3)

25MD1R17 Pusher

Screw (4) 9MC1R2

Shoe (2) 9MC1R1

Point Block a5M1C1R2

Screw (4) 1MA1R5

Screw (2) 1MD1R12

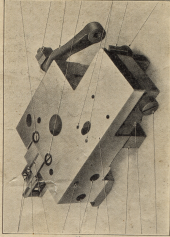
Tie Bar a10MA1R1

Base Plate b1MA1R1

Tie Bar 11MA1R1

Block a9MA1R1

Plug Screw a9MA1R3



2MD1R7 Screw

2MD1R16 Washer

7MA1R5 Lock Nut

a7MA1R3 Lever

1MD1R11 Screw

1MD1R14 Washer

a1MA1R2 Bushing (2)

a9MA1R2 Clamp

9MA1R6 Spring

a9MA1R4 Screw

MOLD REPAIRS

It is not possible for operators to repair MOLDS, for they have neither the special tools nor the necessary training.

If any defects occur in the leads or rules produced by this MOLD that cannot be corrected by following the directions in this folder, the *complete Mold* should be at once returned to us with *samples of the defective product*; enclose these in the box with the *Mold and all its parts*, prepay express charges and write us stating (a) point size and number of MOLD; (b) date of shipment and route; (c) details of trouble.

If the defect is in the face of the RULE, return with the MOLD the Rule MATRIX with which the trouble occurred. Otherwise do not return Rule MATRICES with a MOLD, since they are not a part of the MOLD.

LANSTON MONOTYPE
MACHINE COMPANY

PHILADELPHIA

STYLE 1RB MOLDS

For style 1RB MOLDS a new part (PACKING PIECE a11MD1RB10) has been added and the MATRIX CLAMP 11MD1RB1 has been dropped, because the new PACKING PIECE makes this CLAMP unnecessary. This change requires the following changes in the directions and list of parts.

Substitute the following for ¶48 and ¶49 of the "Directions for Care and Cleaning Continuous Strip Lead and Rule Molds" dated "6-21".

48. The Column Rule MATRIX (.065" drive) and the BHL MATRIX (when used for leads .853" high) go on the TYPE BLOCKS direct; all standard Rule MATRICES (.090" drive) and the BHL MATRIX (when used for leads .888" high) require a PACKING PIECE (11MD1RB7 or a11MD1RB8) between the TYPE BLOCKS and the MATRIX (see "Caution" below).

49. The BHL MATRIX (when used for leads .853" high) and the CAP SUPPORT (a11MC1RB2) require the PACKING PIECE a11MD1RB10 between them and the MATRIX CLAMP 11MD1RB1. Do not use this PACKING PIECE a11MD1RB10 when either PACKING PIECE 11MD1RB7 or a11MD1RB8 is used under a MATRIX, nor with the Column Rule MATRIX.

Under "Note-R5," on the last page of the list of parts, change the group beginning on line four to the following:

TYPE-BLOCK MATRIX CLAMP.....	* 11MD1RB1
matrix packing piece (under Matrix) . . .	† 11MD1RB7
" " " (under Matrix) (low	
shoulder).....	‡a11MD1RB8
packing piece (above Matrix).....	*a11MD1RB10

The notes remain the same as at present.